

Work Order ID 157229

Tuesday, February 21, 2017 7:58:16 AM

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Item ID: D4021-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Handle Plate
Start Date: 2/28/2017 ***4*** Start Qty: 4.00 Cust Item ID:
Required Date: 3/1/2017 ***4*** Req'd Qty: 4.00 Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **FEB 22 2017** Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4021	B								

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4021

Prog Rev: **B**Dwg Rev: **B**

Deburr as required

0.04

(4)**02/17/02/25**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

(4)**02/17/02/25**

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Item Name: Handle Plate
Start Date: 2/28/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/1/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01				4			DAS 38 9-89
Quality Control									FEB 27 2017
140	Identify as per dwg & Stock Location: <u>WA004</u>	0.00							
140									
Packaging	Memo	0.01				fx			DAS 26 9-89
Packaging	LOCATION: WA004								FEB 27 2017
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.07							17/2/28
Quality Control									DAS 21 9-89

FEB 28 2017

Picklist Print

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Work Order ID: 157229

Parent Item: D4021-1

Parent Item Name: Handle Plate

157229
D4021-1

Start Date: 2/28/2017

Required Date: 3/1/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

60.6100

0.1225

0.51579

M304S11GA

304/316 0.125 Sheet

02/17/28/25

Location

Loc Qty

Loc Code

MAT020

60.60998

M129545

0.00109

M134604

1.3

M135355

2.80889

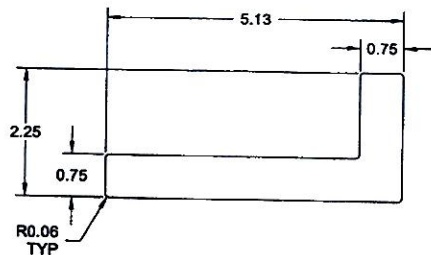
M136327

24.5

M136687

32

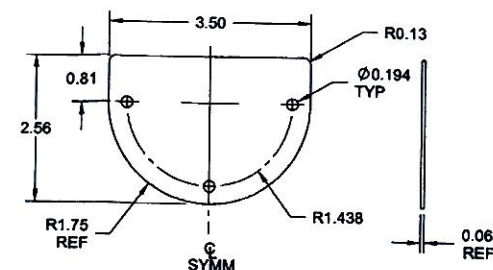
3



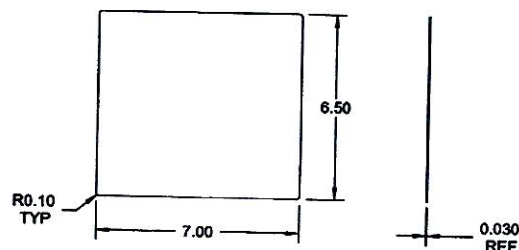
D4021-1 HANDLE PLATE



D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



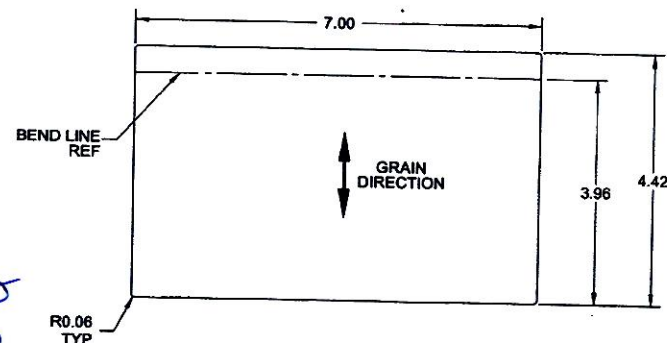
D4021-11 INSTRUCTIONS PLATE

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S18GA OR M304S18GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs
-3: 0.35 lbs
-5: 0.14 lbs
-11: 0.39 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157229 MJS
1702-22



D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
R 2010-04-11
NP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D4021	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		MISC PARTS - 350 BASKET	SCALE
DE APPR.			NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIAL TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	